

Date: Monday, 18/08/2008 3:37:19 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW
Job Number : 41326	
Estimate Number : 12701	
P.O. Number :	Part Number : D119647011
This Issue : 18/08/2008 S.O. No. :	Drawing Number : D3034 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 37719	Material :
Written By :	Due Date : 20/09/2008 Qty: 4- Um: Each
Checked & Approved By : <u>JLD 08.8.18</u>	
Comment : Est Rev:A New Issue 07-02-02 JLM Est Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC Est Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.08



Comment: Photocopy bluefile & type labels per PPP D119-647-011 CHG 002

Soe 10/04

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number

JLD 08.09.19

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.2284 sf(s)/Unit Total : 8.4567 sf(s)
 UHMW 1" Black 28.75" X19.50"
 Batch: M108013

M.A 08/10/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA148 Rev: AA & Dwg D3034 Rev: A

2-Deburr per dwg D3034

M.A 08/10/11

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/10/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:37:19 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 41326

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/10/14

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 0.4809 f(s)/Unit Total: 0.9618 f(s)

Rubber Cushion (6x 5.5")

Batch:

39986

SS 08/16/14 (RV)

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Radius Block

Batch:

41422

SS 08/10/14 (RV)

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Batch:

B38188 x 46 B41431 x 2

SS 08/10/14 (RV)

11.0

D2947

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Clamp

Batch:

36826

SS 08/10/14 (RV)

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

Batch:

M108868

SS 08/10/14 (RV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:37:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 41326

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: ⁴⁸24.0000 Each(s)

Washer

Batch: 1108827

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: ⁴⁸24.0000 Each(s)

Nut

Batch: 1108145

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-647-011

Location: _____

PPP Rev: Rev B

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4 08.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3034DART AEROSPACE LTD		Work Order:	47326
Description: Bearpaw		Part Number:	D3034-1
Inspection Dwg: D3034	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	11.75	+/-0.030	11.751	✓			
B	3.40	+/-0.030	3.430	✓			
C	19.00	+/-0.030	19.000	✓			
D	0.375	+/-0.010	0.380	✓			
E	0.950	+0.030/-0.010	0.954	✓			
F	0.06 x 45°	+0.030/-0.010	0.053x45°	✓			
G	0.25 x 45°	+/-0.030	0.253x45°	✓			
H	R0.25	+/-0.030	R0.25	✓			
I	0.630	+/-0.030	0.631	✓			
J	0.250	+/-0.010	0.253	✓			
K	4.50	+/-0.030	4.530	✓			
L	0.20	+/-0.030	0.198	✓			
M	Ø0.260	+0.005/-0.000	Ø0.260	✓			
N	Ø0.93	+/-0.030	Ø0.930	✓			
O	0.30	+0.030/-0.000	0.312	✓			
P	28.25	+/-0.030	28.25	✓			
Q	0.37	+/-0.030	0.373	✓			
R	4.750	+/-0.030	4.748	✓			
S	9.750	+/-0.010	9.751	✓			
T	11.000	+/-0.010	10.998	✓			
U	8.66	+/-0.030	8.690	✓			
V	5.000	+/-0.010	4.998	✓			

Measured by: H.A	Audited by: SP	Prototype Approval:	N/A
Date: 08/10/12	Date: 08/10/14	Date:	N/A

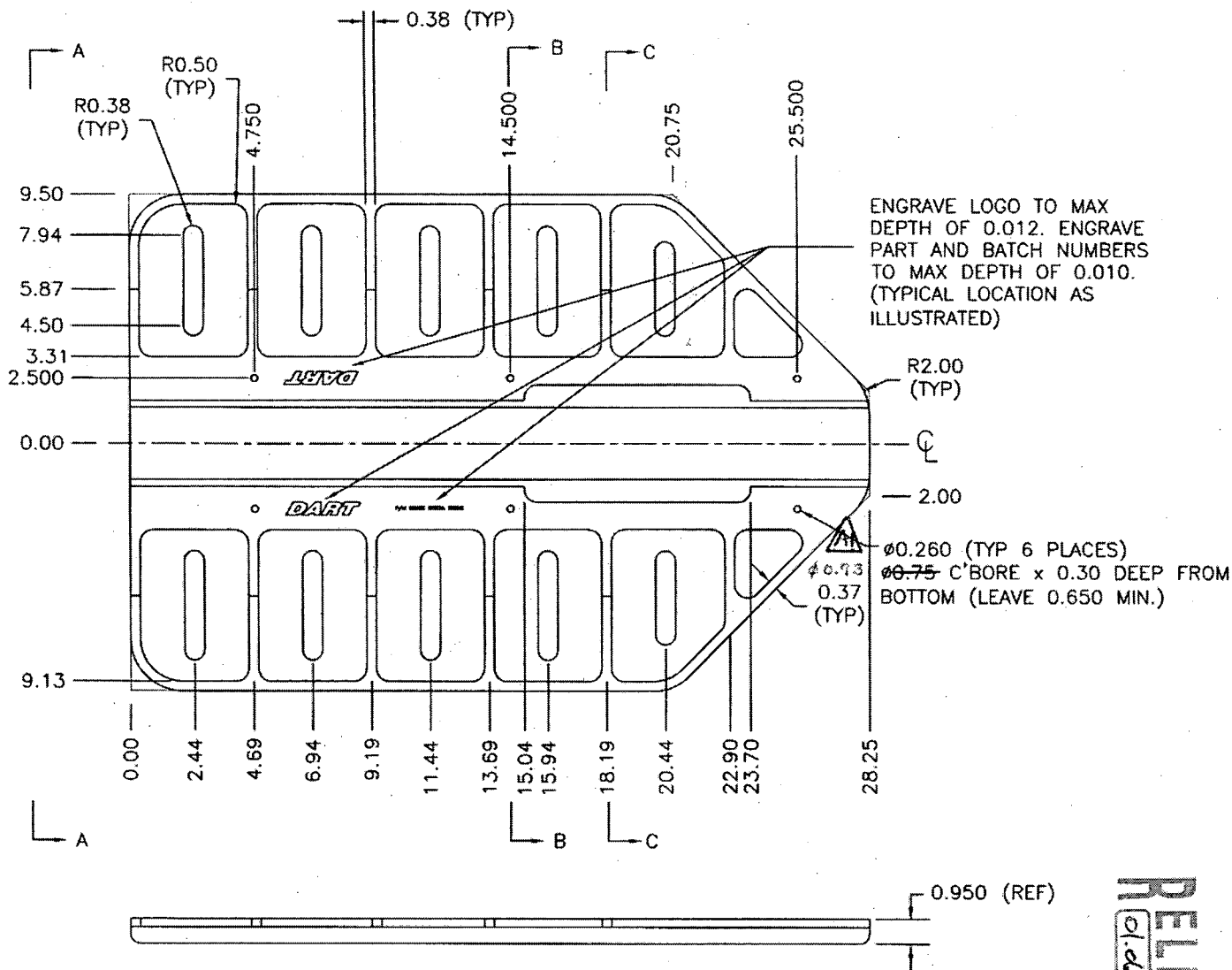
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D119-647-011	KJ/RF	+

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED <i>RF</i>	APPROVED <i>CP</i>	PORT HADLOCK, WA	REV. A
DATE 01.06.21	DRAWING NO. D3034	TITLE BEARPAW	SHEET 1 OF 2
A	01.06.21	NEW ISSUE	SCALE 1:6

RELEASED
01.06.26



D3034-1

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689

1.00 THICK (MACHINE TO 0.950)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO

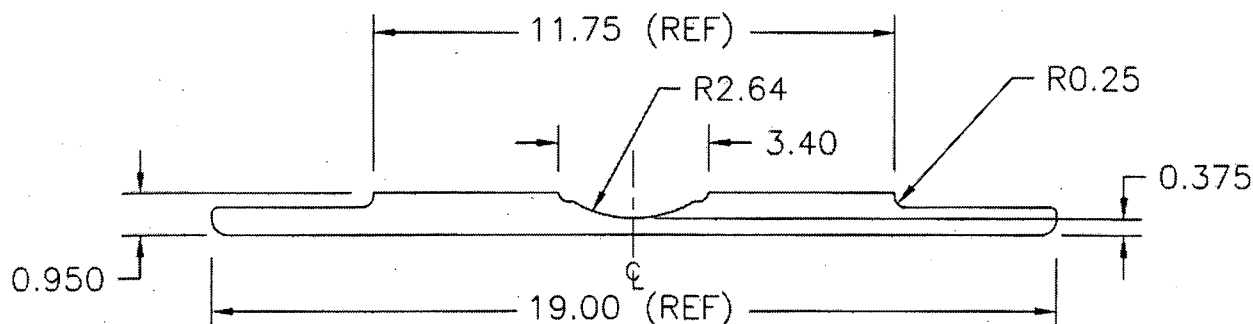
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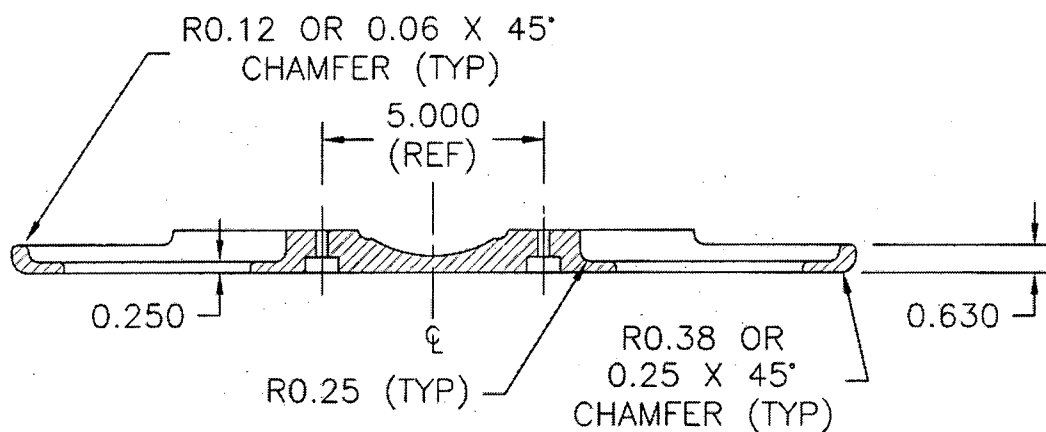
NO. 47326
WORK ORDER



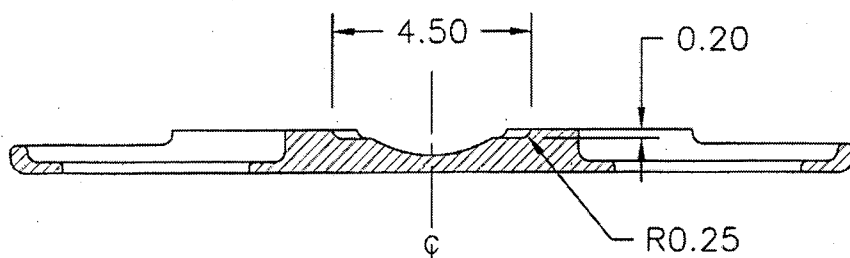
DESIGN H	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3034	REV. A SHEET 2 OF 2
DATE 01.06.21		TITLE BEARPAW	SCALE 1:4



VIEW A-A
(ROTATED 90° CCW)



SECTION B-B
(ROTATED 90° CCW)



SECTION C-C
(ROTATED 90° CCW)

RELEASED

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ENGINEERING

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